

# Work Order ID 83354

\*83354\*

Page 1

April-17-12 2:19:11 PM

Item ID: D4092-042

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Maintenance Step Assembly

Stop \*NS2\*

Start Date: 17/04/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan: MLS

Date: 12/04/12

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D4092

B

100

Pick Kit

0.00

\*100\*

Packaging

Memo

0.00

Packaging

49

*[Signature]*  
12/04/12

110

0.00

\*110\*

Small Fab

Memo

0.00

Small Fab

Assemble as per Dwg  
Torque screws up to 15-25 in- lbs

4x

*[Signature]*  
12/04/12

120

QC5- Inspect part completeness to step on W/O

0.00

\*120\*

QC

Memo

0.00

Quality Control

4

*[Signature]*  
12/04/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Work Order ID 83354

\*83354\*

Page 2

April-17-12 2:19:11 PM

Item ID: D4092-042

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Maintenance Step Assembly

Start Date: 17/04/2012 Start Qty: 4.00

\*4\*

Cust Item ID:

Required Date: 01/05/2012 Req'd Qty: 4.00

\*4\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

Identify as per dwg & Stock Location: 57270

0.00

\*130\*

Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00

\*140\*

QC

Memo

0.00

Quality Control

12/16/12 104

12/16/12 104

ME  
12-06-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

April-17-12 2:19:15 PM

Page 1

Work Order ID: 83354

**\*83354\***

Parent Item: D4092-042

**\*D4092-042\***

Parent Item Name: Maintenance Step Assembly

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A NEW ISSUE 10-10-08 JLM VERIFIED:DD  
REV:B AS PER ECN 11-639 JLM VERIFIED BY:DD

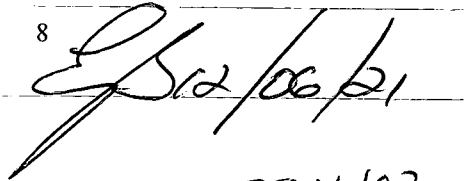
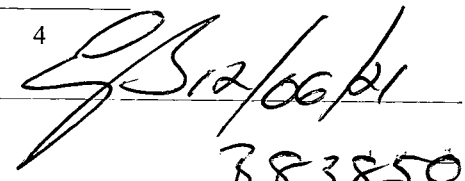
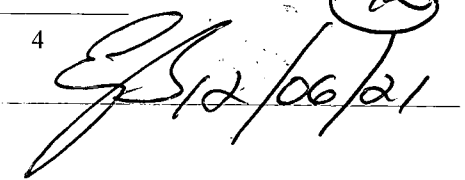
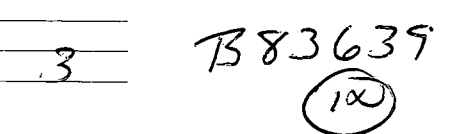
IPP

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4092-1 <b>*D4092-1*</b> Maintenance Step		Manufactured	No				Each	6.0000		8			
				<u>Location</u>				<u>Loc Qty</u>					
				GA				5					
				77852				1					
				80564				2					
				81734				2					
				ST241A				1					
				74303				1					
D4093-1 <b>*D4093-1*</b> Bracket		Manufactured	No				Each	7.0000		4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST195				7					
				78911				7					
D4093-3 <b>*D4093-3*</b> Bracket		Manufactured	No				Each	33.0000		4			
				<u>Location</u>				<u>Loc Qty</u>					
				ST195				33					
				77850				1					
				80084				20					
				82767				12					

\*\*

\*\*

\*\*

384402  
 383850  
 383639

(8x)  
 (4x)  
 (1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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April-17-12 2:19:15 PM

Page 2

Work Order ID: 83354

**\*83354\***

Parent Item: D4092-042

**\*D4092-042\***

Parent Item Name: Maintenance Step Assembly

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 4.00

Required Qty: 4.00

D4093-5 Manufactured No

Each 54.0000

8

**\*D4093-5\***

Bracket

\*\*

Location

Loc Qty

Loc Code

ST124

54

80085

2

80226

12

82764

40

MS24694-S54

Purchased No

Each 124.0000

8

**\*MS24694-S54\***

Screw

\*\*

Location

Loc Qty

Loc Code

ST289A

124

120142

4

120361

20

121166

100

MS24694-S55

Purchased No

Each 148.0000

32

**\*MS24694-S55\***

Screw

\*\*

Location

Loc Qty

Loc Code

ST289A

148

119307

33

120833

15

120910

100

MS24694-S56

Purchased No

Each 159.0000

8

**\*MS24694-S56\***

SCREW

\*\*

Location

Loc Qty

Loc Code

ST289A

159

120142

34

120833

25

121340

100

April-17-12 2:19:15 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries



# Picklist Print

April-17-12 2:19:15 PM

Page 3

Work Order ID: 83354

\*83354\*

Parent Item: D4092-042

\*D4092-042\*

Parent Item Name: Maintenance Step Assembly

Start Date: 17/04/2012

Required Date: 01/05/2012

Start Qty: 4.00

Required Qty: 4.00

NAS1149D0332J

Purchased

No

Each

2,955.000

48

\*NAS1149D0332.J\*

\*\*

Washer

Location

Loc Qty

Loc Code

ST298

2955

105793

12

110985

4

117087

89

119042

38

119717

544

120644

277

121011

1991

MS21042L3

Purchased

No

Each

2,891.000

48

\*MS21042I 3\*

\*\*

Nut

Location

Loc Qty

Loc Code

ST300

2891

117441

16

117885

32

118451

5

118927

3

119017

1677

119075

158

121349

1000

M121444  
48

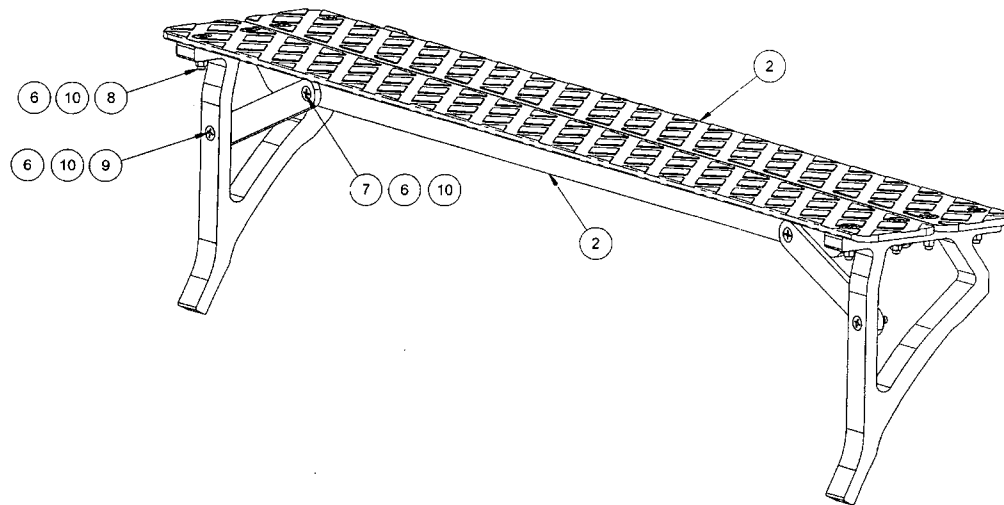
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries



**D4092-041 MAINTENANCE STEP ASSEMBLY**



ITEM	QTY -041	PART NUMBER	DESCRIPTION
1	X	D4092-041	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACE
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER

NO. 83354 MLJ  
12/04/17

**RELEASED**  
2011-09-22  
JWD

B	REDRAWN; LOWERED FOR AESTHETICS	RF	11.07.27
A	NEW ISSUE	RF	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	<i>140</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>21</i>	D4092	SHEET 1 OF 6
APPROVED	<i>140</i>	TITLE	SCALE
DE APPR.	<i>140</i>	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

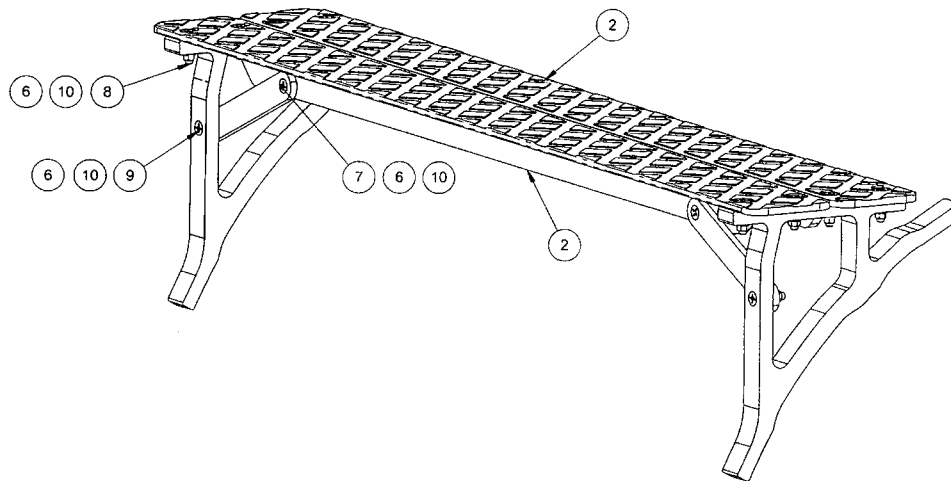
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4092-042	MAINTENANCE STEP ASSEMBLY
2	2	D4092-1	MAINTENANCE STEP
3	1	D4093-1	BRACKET
4	1	D4093-3	BRACKET
5	2	D4093-5	BRACKET
6	12	MS21042L3	NUT
7	2	MS24694-S54	SCREW
8	8	MS24694-S55	SCREW
9	2	MS24694-S56	SCREW
10	12	NAS1149D0332J	WASHER



**D4092-042 MAINTENANCE STEP ASSEMBLY**



**RELEASED**  
2011-09-22  
JW

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CHECKED	<i>RF</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>RF</i>	<b>D4092</b>	SHEET 2 OF 6
APPROVED	<i>RF</i>	TITLE	SCALE
DE APPR.	<i>RF</i>	<b>MAINTENANCE STEP ASS'Y</b>	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

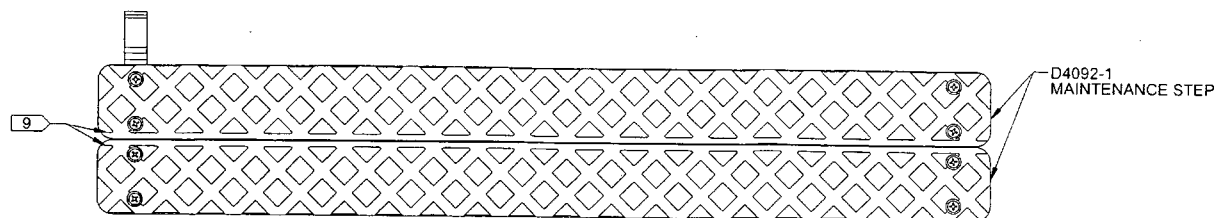
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

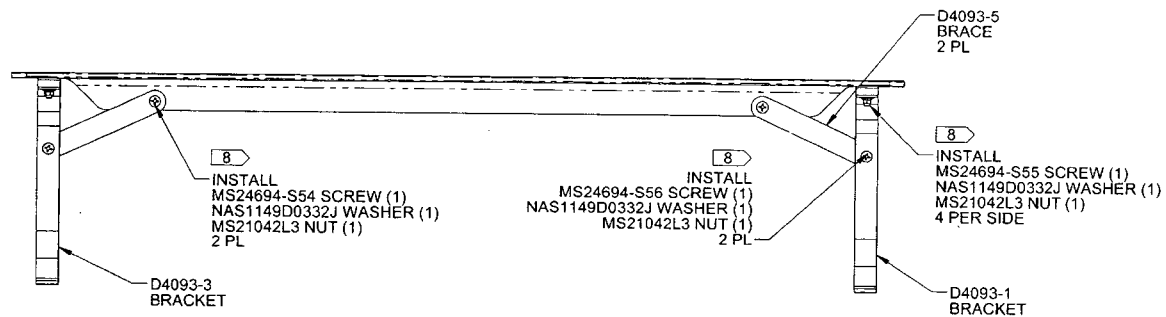
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

83354



D4092-1  
MAINTENANCE STEP



8  
INSTALL  
MS24694-S54 SCREW (1)  
NAS1149D0332J WASHER (1)  
MS21042L3 NUT (1)  
2 PL

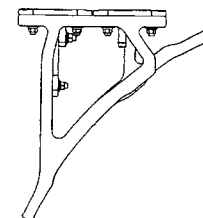
8  
INSTALL  
MS24694-S56 SCREW (1)  
NAS1149D0332J WASHER (1)  
MS21042L3 NUT (1)  
2 PL

D4093-5  
BRACE  
2 PL

8  
INSTALL  
MS24694-S55 SCREW (1)  
NAS1149D0332J WASHER (1)  
MS21042L3 NUT (1)  
4 PER SIDE

D4093-3  
BRACKET

D4093-1  
BRACKET



# D4092-041 MAINTENANCE STEP ASSEMBLY

RELEASED  
2011-09-22

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	RF	KENT, WA	
CHECKED	140	DRAWING NO.	REV. B
MFG. APPR.	21	D4092	SHEET 3 OF 6
APPROVED	140	TITLE	SCALE
DE APPR.	140	MAINTENANCE STEP ASS'Y	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

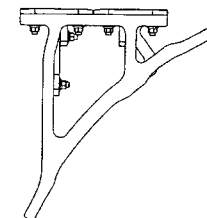
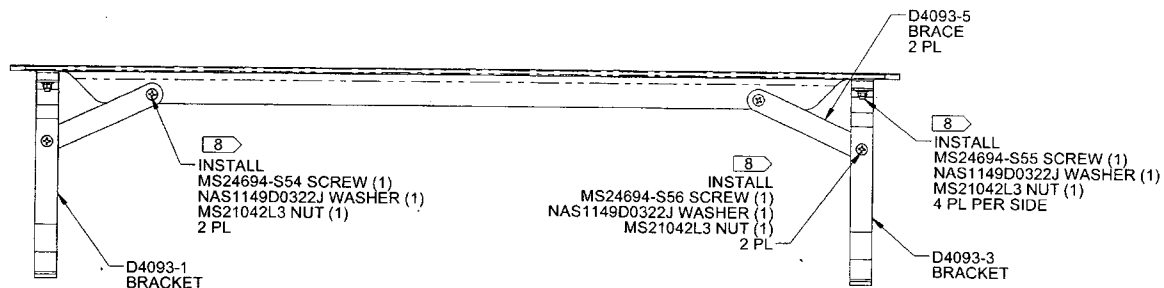
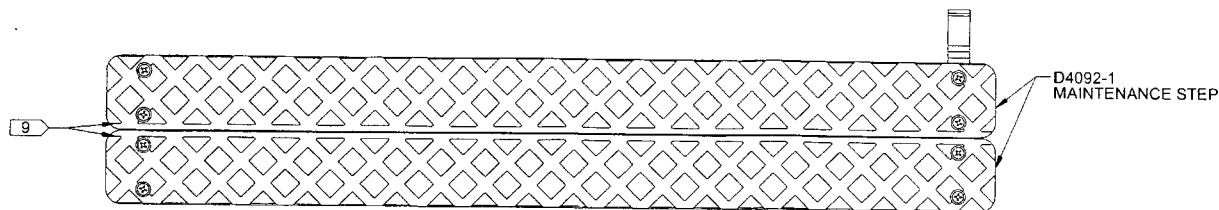
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



83354



RELEASED  
2011-09-22

**D4092-042 MAINTENANCE STEP ASSEMBLY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 5.37 lbs
- 8) TORQUE SCREWS UP TO 15-25 in-lb (1.7-2.8 N-m)
- 9) GRIP CUTOUT TOWARD CENTER

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO. D4092	REV. B
MFG. APPR.	RF	SHEET 4 OF 6	
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	MAINTENANCE STEP ASS'Y	NTS
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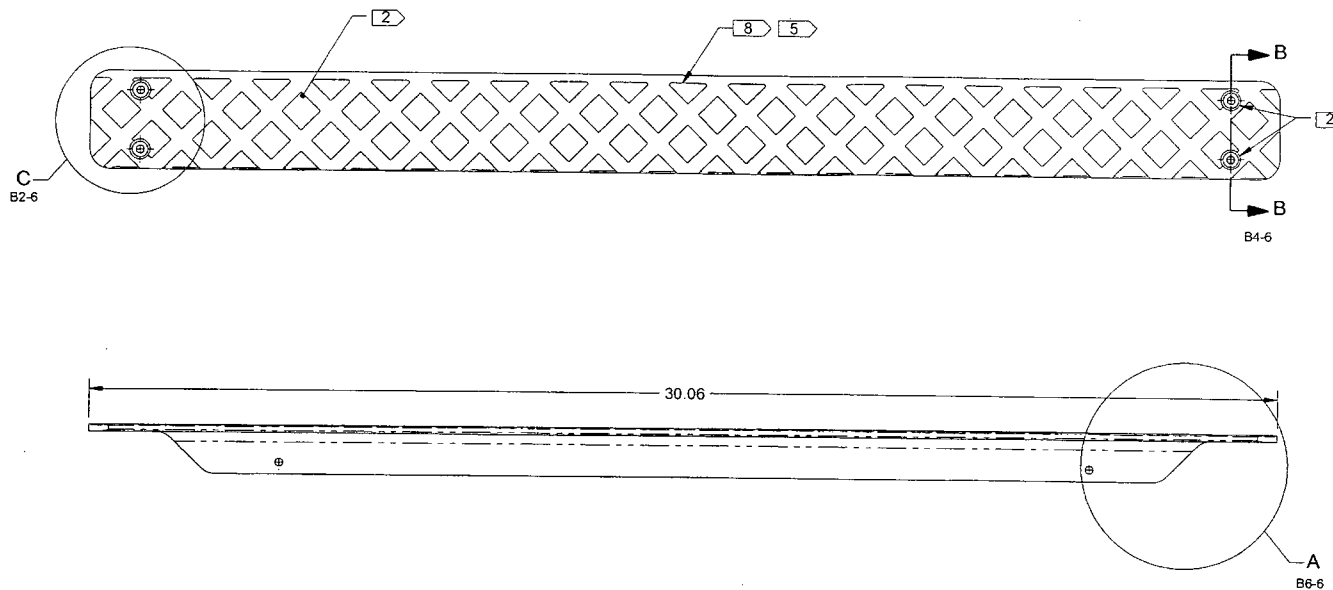
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**D4092-1 MAINTENANCE STEP**  
(MAKE FROM D2761 EXTRUSION)

**RELEASED**  
2011-09-22  
JW

**NOTES:**

- 1) MATERIAL: MAKE FROM D2761 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
BLACK ANTI-SKID PAINT GRIP AREA AS INDICATED PER DART QSI 005 4.4  
MASK RECTANGULAR CUTOUT PRIOR TO APPLICATION OF ANTI-SKID
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX, NOT REQUIRED TO DEBURR GRIP AREA
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.97 lbs
- 8) MACHINE 0.69 x 0.69 GRIP 0.030 DEEP AT 45° PATTERN 0.38 APART

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b> KENT, WA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	<b>D4092</b>	SHEET 5 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	<b>MAINTENANCE STEP ASS'Y</b>	NTS
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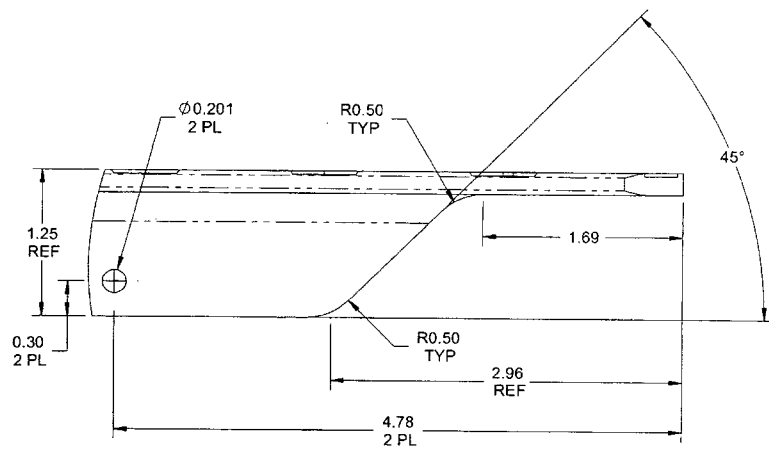
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

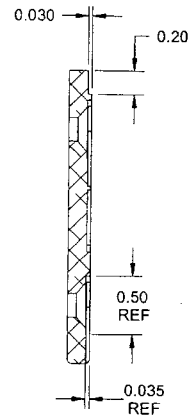
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

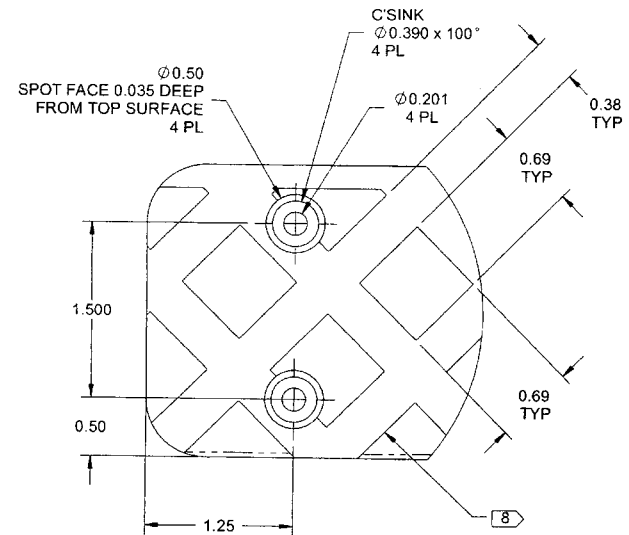
23354



**DETAIL A**  
SCALE 3X, TYP B3-5



**SECTION B-B**  
SCALE 3X, TYP C3-5



**DETAIL C**  
SCALE 3X, TYP C8-5

**RELEASED**  
2011-09-22  
JW

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4092	SHEET 6 OF 6
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MAINTENANCE STEP ASS'Y	NTS
DATE	11.07.27	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries